

Work Order ID 70868

Thursday, June 16, 2011 12:42:47 PM



Page 1

Item ID: D3023-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Back Panel

Start Date: 6/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: W

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3023	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3023

Dwg Rev: A

Prog Rev: A

***graind direction along 28.100" ***

2-Deburr if necessary

B11-7-11

①

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-7-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
130  Brake NC Brake NC	NC BRAKE Memo 1-Bend as per Dwg D3023 12-form edge of back pan as per dwg D3023 using D3017-041 back frame <i>EL 11-8-3.</i>	0.00 0.00							
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

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Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 of 11 4/10/08/01

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:15am FINISH TIME: 3:20pm

OVEN TEMPERATURE:

1 of 11 4/10/08/01

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1X of 11 4/10/08/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location

G.A

0.00



Packaging

Memo

w/o
70903

0.00

Packaging

ES 11/08/10 @

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CR 11/08/10

11-08-10
@

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 16, 2011 12:42:44 PM

Page 1

Work Order ID: 70868



Parent Item: D3023-1



Parent Item Name: Back Panel

Start Date: 6/16/2011

Required Date: 6/24/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C 02.01.23 Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased	No			100	sf	30.4000	2.8777	3.029158			
											B11-7-11		

2024-T3 .032 sheet

Location	Loc Qty	Loc Code
MAT22	30.4	
111699	0.5	
113189	29.9	

118242

①

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 70868
Description: Back Panel		Part Number: D3023-1
Inspection Dwg: D3023	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

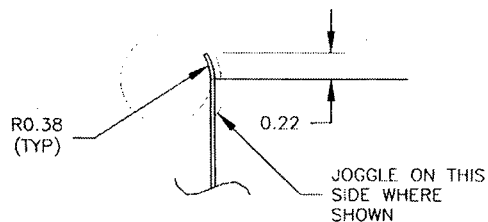
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.131			V B02	
Ø0.191	+0.005/-0.001	.193			V	
1.660	+/-0.010	1.660			V	
0.375	+/-0.010	.374			V	
1.340	+/-0.010	1.341			V	
2.375	+/-0.010	2.373			V	
0.375	+/-0.010	.373			V	
25.28	+/-0.030	25.28			T B01	
27.03	+/-0.030	27.03			T	
28.10	+/-0.030	28.18			T	
1.30	+/-0.030	1.298			V	
2.375	+/-0.010	2.374			V	
8.711	+/-0.010	8.71			V	
5.597	+/-0.010	5.597			V	
8.57	+/-0.030	8.57			V	
1.970	+/-0.010	1.967			V	
7.42	+/-0.030	7.42			V	
10.92	+/-0.030	10.92			T	
14.75	+/-0.030	14.75			T	

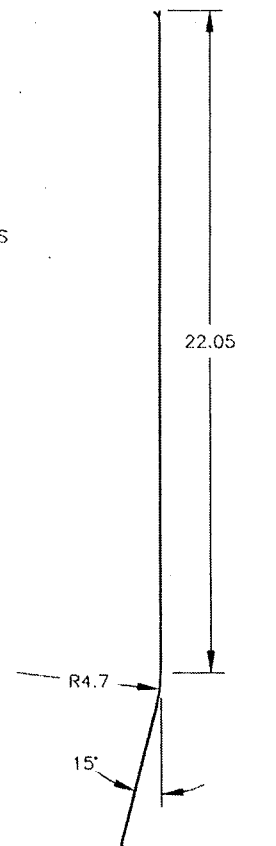
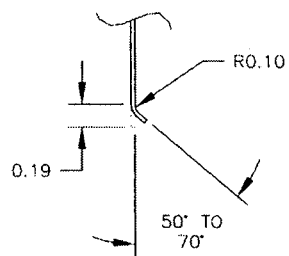
Measured by: TB	Audited by: S	Prototype Approval:	N/A
Date: 11-7-11	Date: 11/6/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC	AS

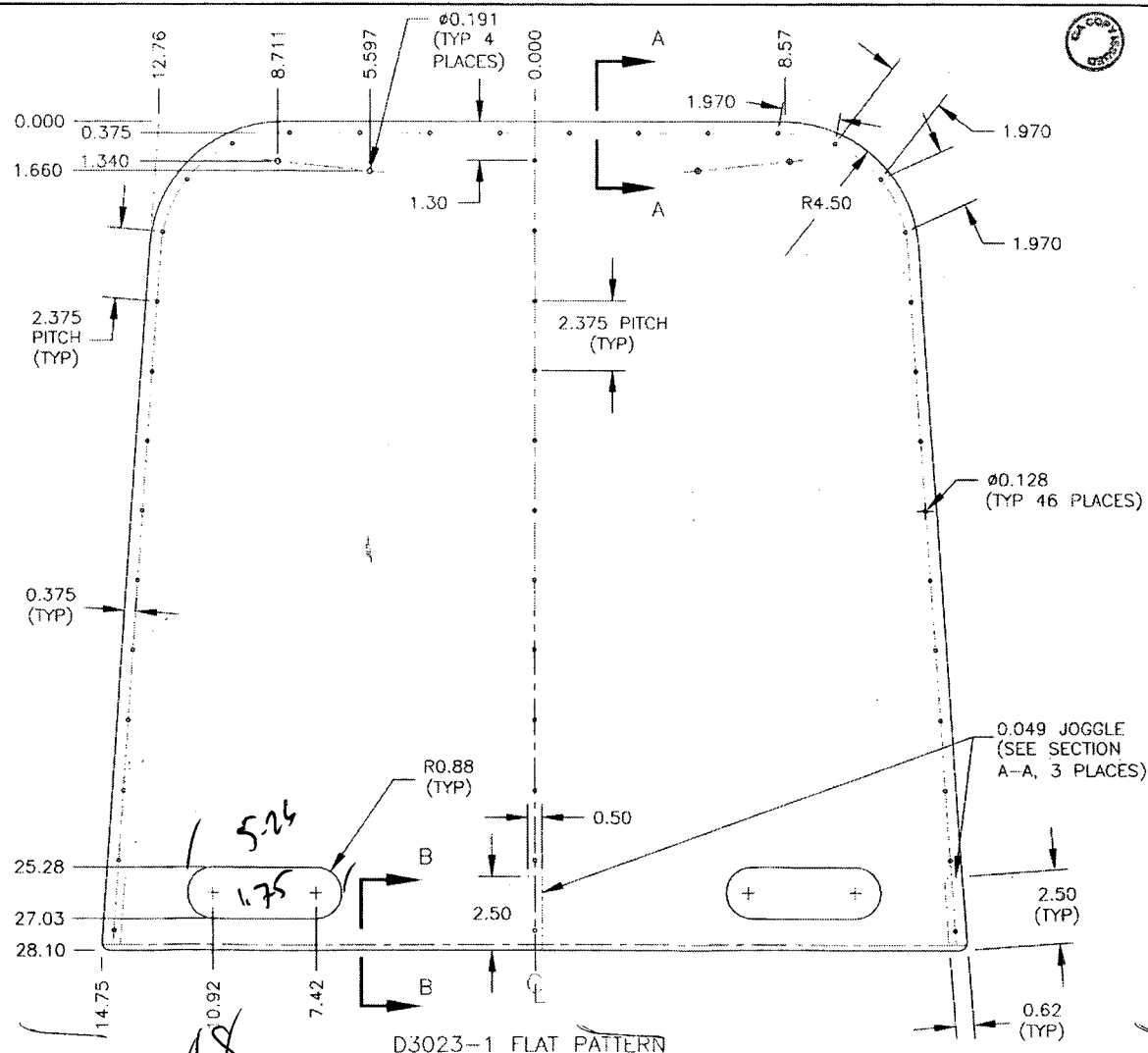
SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)



SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (Q0-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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DART AEROSPACE LTD.

A	01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023
DATE	01.05.18	TITLE BACK PANEL
		REV. A SHEET 1 OF 1 SCALE 1:4